

Monday, June 08, 2015 4:12:32 PM

Page 1

NS1

Stop *NS2*

10

10

Reference:

Run Start *NR1*

Date: JUN 10 2015

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

**Insp.
Stamp**

D4775

C

110

Pick Kit

0.00

110

Large Fab

0.00

Packaging

Memo

Packaging

120

0.00

120

0.00

Small Fab

Small Fab

Memo

1- APPLY PROSEAL ON D4776-1 STRUT AND ASSEMBLE AS PER DWG

A/R PROSEAL BATCH: M132226

2- ENSURE HELICOIL DOES NOT BLOCK HOLE (SEE NOTE 9)

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

Work Order ID 133493

133493

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Item ID: D4775-041 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Strut Assembly
Start Date: 6/08/15 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 6/08/15 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC5- Inspect part completeness to step on W/O	0.00							38 9-88
130						(10)			JUN 24 2015
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location: <u>st 514</u>	0.00				10			27 6-89
140									JUN 24 2015
Packaging	Memo	0.00							
Packaging									
150	QC21- Final Inspection - Work Order Release	0.00							JUN 24 2015
150									ML5
QC	Memo	0.00							JUN 24 2015
Quality Control									

ML5 JUN 24 2015

DQA: _____ Date: _____



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Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
OTHER : _____					

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133493

D4775-041

Required Date: 6/08/15

Required Qty: 10.00

AS PER REV.C DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4775-1		Manufactured	No			110	Each	5.0000	1	10			
D4775-1 ** <u>FF</u> JUN 2 3 2015													
Strut Tube													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST514	515		5			<u>5</u>			
				129407	133514		5			<u>5</u>			
D4777-1		Manufactured	No			110	Each	17.0000	1	10			
D4777-1 ** <u>FF</u> JUN 2 3 2015													
Rod End Bearing													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST127			17			<u>10</u>			
					132572		17						
D4776-1		Manufactured	No			110	Each	20.0000	1	10			
D4776-1 ** <u>FF</u> JUN 2 3 2015													
Basket Strut Clevis													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST126			20			<u>10</u>			
					132511		20						
D4776-5		Manufactured	No			110	Each	26.0000	4	40			
D4776-5 ** <u>FF</u> JUN 2 3 2015													
Spacer													
				<u>Location</u>			<u>Loc Qty</u>	<u>Loc Code</u>					
				ST127	B133591		26			<u>14</u>			
					132792		26			<u>26</u>			

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OTHER : ☐					

Picklist Print

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Work Order ID: 133493

133493

Parent Item: D4775-041

D4775-041

Parent Item Name: Strut Assembly

Start Date: 6/08/15

Required Date: 6/08/15

Start Qty: 10.00

Required Qty: 10.00

AN3-10A

Purchased

No

110

Each

244.0000

2

20

AN3-10A

Bolt

FF

JUN 23 2015

Location

Loc Qty

Loc Code

ST338a

68

m130466

68

ST349

176

m131957

2

m132317

174

20

MS21042L3

Purchased

No

110

Each

2,244.000

2

20

MS21042L3

Nut

FF

JUN 23 2015

Location

Loc Qty

Loc Code

FP001

420

M130922

420

GA

503

M131317

503

ST305

1321

116549

12

126333

49

M128754

2

M132123

258

M132382

1000

20

MS21209-F615

Purchased

No

110

Each

76.0000

1

10

MS21209-F615

Heli-Coil

FF

JUN 23 2015

Location

Loc Qty

Loc Code

GA

76

m131270

2

m132164

74

10

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Shop Packet Print

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